

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029466**Date Inspected:** 19-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Welder Wai Kit Lai #2953:

The welder was observed performing in process welding as per ABF-RFI-003190R00 by re aligning the misalign Traveler Rail Bracket Support in way of the West OBG at Panel Point 118.35W. The welder was observed welding utilizing the Welding Procedure Specification (WPS) ABF-WPS-D15-1060A for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Salvador Merino and appeared to be in compliance with the WPS noted above.

Non-Destructive Testing (NDT)

This QA performed NDT on the following:

Seal Cover Plate Welds at 12W PP119 (-1500) as per ABF-RFI-003256R00.

- Visual Testing 100% (VT Accept).
- Magnetic Particle Testing 100% (MPT Accept).
- See report form TL-6028 for details. (Report dated 2013.04.20)

Electroslag Weld ESW M, W042:

- UTSW Pitch/Catch at Y 4680 & 4520.
- See report below.

WELDING INSPECTION REPORT

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Weld: ESW M, W042 (Face B), 60mm Thick, Transducer Angle 69 Degrees:

Y: 4680 X: -10, SoundPath: 114, Depth (Fc A):20,

PEUT: Ind.Lvl (A): 77, Ref.Lvl(B): 60, Att.Factor(C): 7, Ind.Rating (D): 10, Surface Distance: 106

PCUT: Ind.Lvl (A):78, Ref.Lvl(B): 60, Att.Factor(C): 10, Ind.Rating (D): 8, Transducer Spacing: 102

Y: 4520 X: -10, S. Path: 110 Depth (Fc A):21

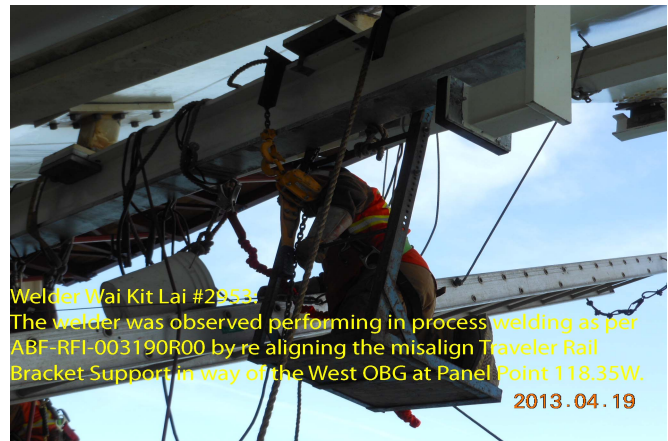
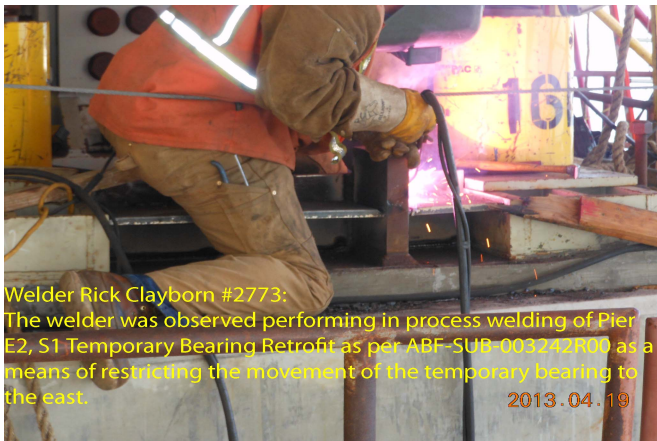
PEUT: Ind.Lvl (A): 73 Ind.Ref.Lvl(B): 60 Att.Factor(C): 7 Ind.Rating (D): 6 Surface Distance: 103

PCUT: Ind.Lvl (A):77 Ref.Lvl(B):60 Att.Factor(C): 10 Ind.Rating (D): 7 Transducer Spacing: 100

Pitch Catch Ultrasonic Testing performed this day was for informational purposes only. Welds inspected are to be reinspected with an approved inspection procedure at a later date.

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By: Belford,Fritz

Quality Assurance Inspector

Reviewed By: Mertz,Robert

QA Reviewer